

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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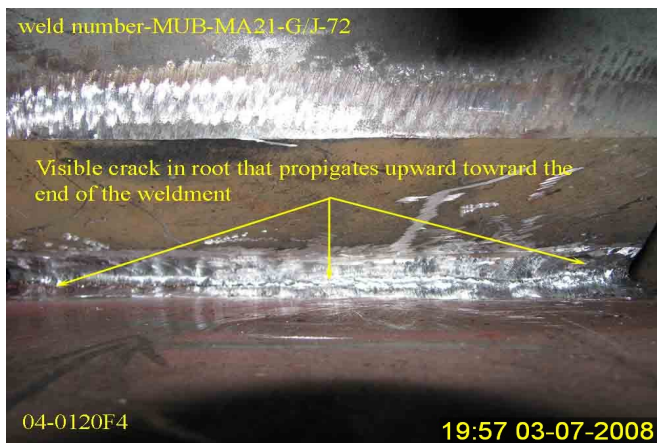
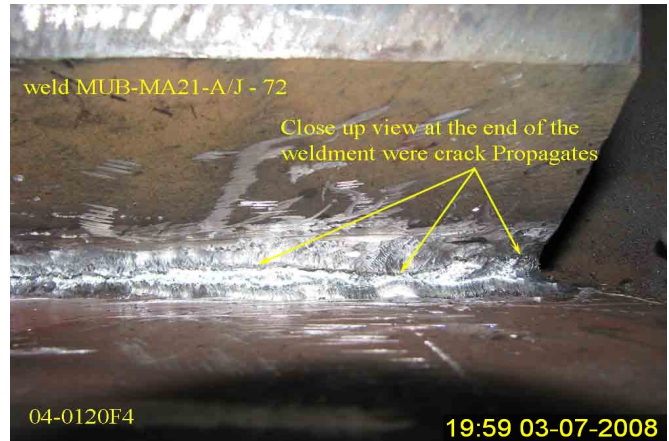
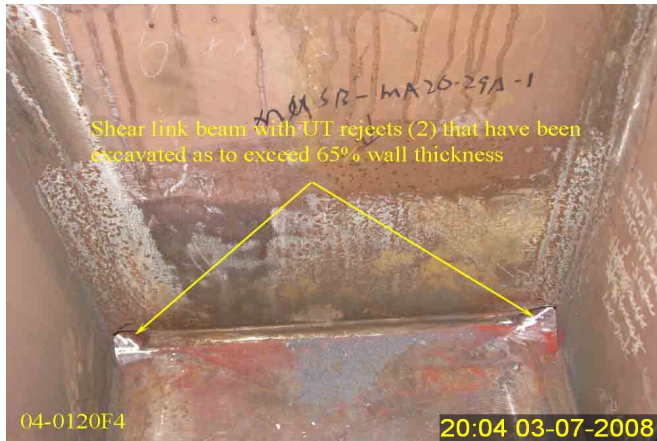
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001723**Date Inspected:** 07-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Sha Zhi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower 89m Mock-up**Summary of Items Observed:**

This Quality Assurance (QA) inspector upon arrival at ZPMC for observation of the 89m mock up observed and witnessed ZPMC personnel performing Magnetic Particle (MT) inspection for the root pass on a Partial Penetration (PJP) Groove weld number MUB-MA21-G/J 72 by MT Technician Cai Xin Xin. It was relayed to this QA inspector that the root pass was acceptable with no rejectable indications noted. While performing the observation it was noted that ZPMC performed 2 excavations for Ultrasonic Testing (UT) rejectable indications on shear link beam MA26-1 weld number MUSB-MA26-29A-1 were beyond 65% thickness of the material see digital photo below. This QA inspector spoke with ZPMC QC inspector Shen Xue Jun and Certified Welding Inspector (CWI) Sha Zhi in regards to the depth. Also noted was A PJP weldment number MUB-MA21-A/J-72 which had a visible crack for the complete length of the weld. ZPMC had relayed that they believed it to be the root gap creating the indication line but upon further review it was noted that the line did not stay parallel to the groove but traveled in an upward fashion see digital photo below. It was relayed to this QA inspector that the QC and CWI inspector would relay the information to their production department for further review of both areas of concern and for direction of how to proceed.

WELDING INSPECTION REPORT

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Summary of Conversations:

As Noted in content above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Riley,Ken	Quality Assurance Inspector
Reviewed By:	Hager,Craig	QA Reviewer
